








Work Order ID 70768




Wednesday, June 15, 2011 9:07:37 AM

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Item ID:	D3490-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cross Bolt Spacer					
Start Date:	6/15/2011	Start Qty:	60.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	60.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	11/06/15	Tooling:	Date:	Run	Start	
	QC:	Date:		SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3490	Rev A								

100	Hardinge CNC LATHE SMALL	0.00				59	60	φ	
	Hardinge	Memo							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV: <u>UJA</u> DWG REV: <u>3/1</u> 2-DEBURR AS REQUIRED		JA	11/06/16					
110	QC2- Inspect parts off machine FAI/FAIB	0.00				59	60	φ	
	QC	Memo							
Quality Control			JA	11/06/16					
120	QC8- Inspect parts - second check	0.00				59	φ		
	QC	Memo							
Quality Control			JA	11/06/21					

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Item ID: D3490-3

Accept

Revision ID:

Item Name: Cross Bolt Spacer

Start Date: 6/15/2011 Start Qty: 60.00

Required Date: 6/22/2011 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

11/6/22 J (59x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22 J

mf
11-06-22

Picklist Print

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Work Order ID: 70768

Parent Item: D3490-3

Parent Item Name: Cross Bolt Spacer


Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit 281	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	58.8030	0.266	16.8			
													
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT013

58.803

112442

0.796

116406

0.617

117481

57.39

17 RF

156116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

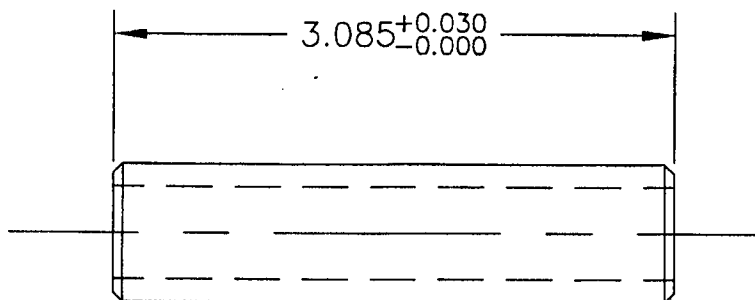
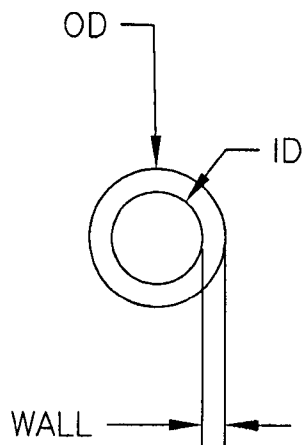
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER SCALE NTS	
A	06.01.04	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *70768* *PH-06-15*

0.050 X 45°
CHAMFER (TYP)

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries